

# Work Order ID 60159

June 28, 2010 11:33:03 AM



Page 1

Item ID: D350-636-014

Revision ID:

Item Name: Skidtube RH

Start Date: 6/28/10 Start Qty: 1.00

Required Date: 7/05/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 005

S. Solis

for BG 10/07/22

B60159

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DOA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60159

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Item ID: D350-636-014

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.


6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)  
\*\*\*ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150\*\*\*

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Clecko DT\_\_\_\_\_ and drill fwd saddle holes on second side, ensure proper positioning.

9- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

10-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

  
10-6-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DCA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 60159

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Item ID: D350-636-014

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.297"

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: 1114242

13-Grind welds flush as per Dwg D2750

0.00

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

120



QC

Quality Control

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

> DP

10-6-28

BE 10/07/01  
BE 10/07/05

8/06/05

8/06/05

⑦

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: Date:

QC: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1



HandFinish

Memo

Hand Finishing

150

QC3- Inspect Part Finish



QC

Memo

Quality Control

Accept



Setup Start

Stop

Cust Item ID:

Customer:



1 11/27/06

1 2E 10/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DCA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R: Sikaflex-291 batch: M113519  
exp. date: 12/11/20

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)

A/R: Aluminum Rod batch: M114242

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

460717

BE 10/07/12

BE 10/07/12

**Work Order ID 60159**

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.



Cust Item ID:

Customer:



810607/13

810607/13

(H)

=7 10607/16

21

φ

# Work Order ID 60159

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Item ID: D350-636-014

Accept

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:00

OVEN TEMPERATURE: 325

FINISH TIME: 9:30

1 BR 10-719.

210

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

=> M 10/07/21

1 Q

# Work Order ID 60159

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Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 6/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230



HandFinish

Hand Finishing

HandFinishing

0.00

7/11

10/07/21

1

0

Memo

0.00

✓ 1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube

✓ A/R 55-o'ring lube batch: M114189

✓ 3-Assemble tube hardware as per dwg D2750

sikaflex batch: M115114

11/01

✓ 4-Inspect For Foreign Objects

✓ 5-Spray inside of tube with "LPS-3" batch: 10/1

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M115114

EXP DATE: 11/01

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

✓ A/R 55-o'ring lube batch: M114189

8-Coat all exposed fasteners with "LPS Procyon"

batch: M1104251

# Work Order ID 60159

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Page 9

Item ID: D350-636-014

Revision ID:

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Start Date: 6/28/10 Start Qty: 1.00

Required Date: 7/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/21

(10)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

8/10/07/22 (1)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/07/23

(10)

# Work Order ID 60159

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Item ID: D350-636-014

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Start Date: 6/28/10 Start Qty: 1.00

Required Date: 7/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-014

NRUH

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W 1007.26

10/07/26

CP 6/23

# Picklist Print

June 28, 2010 11:32:46 AM

Page 1

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H: 02.09.25: Rearranged procedure steps: KJ: I  
 IPP Rev:I: 05.12.08: Rearranged procedure steps: EC: I  
 IPP Rev:J: 06.03.30: Per rev. D: I: EC  
 IPP Rev:L: 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M: 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT



Extrusion Bent

D2739



350 I Beam

Manufactured No

110

Each

0.0000

1

1

Manufactured No

160

Each

2.0000

1

1

Location

Loc Qty

Loc Code

LG

2

59406

2

D2743



Crossbolt Spacer

Manufactured No

160

Each

331.0000

8

8

Location

Loc Qty

Loc Code

LG

331

50281

10

57953

2

59111

319

D2744



Cap

Manufactured No

160

Each

42.0000

1

1

Location

Loc Qty

Loc Code

LG

42

51922

6

59198

36

*B59410 (x1) BE 10/07/12*

*DB 60225 N 6/7/7*

*B BE 10/07/12*

*1 BE 10/07/12*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DOA: \_\_\_\_\_ Date: \_\_\_\_\_

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June 28, 2010 11:32:46 AM

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Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3490-1      Manufactured      No      160      Each      35.0000      4      4  
 Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	35	
59424	35	

D3490-5      Manufactured      No      160      Each      82.0000      4      4  
 Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	82	
46490	22	
59230	60	

ALS4-1032-225      Purchased      No      230      Each      6,491.000      38      38  
 Insert

Location	Loc Qty	Loc Code
PK011	6491	
110768	6491	

AN3C5A      Purchased      No      230      Each      1,232.000      34      34  
 Bolt

Location	Loc Qty	Loc Code
ST350	1217	
114330	11	
114523	18	
114808	188	
115015	1000	
ST351	15	
113121	10	
114108	5	

4 BE 10/07/12

4 BE 10/07/12

x34 10/07/12

x34 10/07/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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# Picklist Print

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Page 3

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 501.0000 4 4



BOLT

Location Loc Qty Loc Code

ST351 501

11982

501

x4 yd 10/07/20

AN6C44A Purchased No 230 Each 217.0000 4 4



BOLT

Location Loc Qty Loc Code

FG 2

103964 2

ST344 215

111649 2

114653 38

114784 50

114941 75

115030 50

x4 yd 10/07/20

AN8C35A Purchased No 230 Each 38.0000 1 1



BOLT

Location Loc Qty Loc Code

FP 1

110847 1

ST346 37

114442 37

x1 yd 10/07/20

AN960C10L Purchased No 230 Each 0.0000 38 38



washer

1115000 x38 yd 10/07/20

June 28, 2010 11:32:47 AM

Shop Packet Print

Page 3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230 Each

57.0000

1 1



WASHER

## Location

## Loc Qty

## Loc Code

ST348

57

110584

54

111424

3

X1 JV 10/07/20

D2745

Manufactured No

230 Each

246.0000

8 8



Bushing.

## Location

## Loc Qty

## Loc Code

ST023

246

52311

5

57914

21

59112

220

X8 JV 10/07/20

D3488-042

Manufactured No

230 Each

11.0000

1 1



Blade Fitting Assembly, RH

## Location

## Loc Qty

## Loc Code

FP008

11

53918

11

X1 JV 10/07/20

D3492-1

Manufactured No

230 Each

18.0000

8 8



Plug

## Location

## Loc Qty

## Loc Code

FP

18

48274

18

X8 JV 10/07/20

replaces D3492-041

Shop Packet Print

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Start Qty: 1.00

Required Qty: 1.00



D3492-5 Manufactured No

230 Each 0.0000 8 8

Plug  
replaces D3492-045

1351638



X8 MJ 10/07/20



D3535-25 Manufactured No

230 Each 9.0000 1 1

Wearshoe



Location

Loc Qty

Loc Code

FP18

9

59150

9

X1 MJ 10/07/20



D3536-25 Manufactured No

230 Each 39.0000 1 1

Gasket



Location

Loc Qty

Loc Code

FP12

39

58820

15

59625

24

X1 MJ 10/07/20



D3537-1 Manufactured No

230 Each 50.0000 3 3

Wearpad



Location

Loc Qty

Loc Code

FP

1

55465

1

1359543

X3 MJ 10/07/20

FP17

25

57713

3

59116

22

FP18

24

59710

24

June 28, 2010 11:32:48 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June 28, 2010 11:32:49 AM

Page 6

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No 230 Each 351.0000 8 8



Washer

Location Loc Qty Loc Code

ST076 351  
52693 206  
54388 145

D3672-1 Manufactured No 230 Each 1,159.000 4 4



Phenolic Washer

Location Loc Qty Loc Code

ST077 1159  
54674 159  
52505 1000

D3791-1 Manufactured No 230 Each 18.0000 1 1



Wearplate

Location Loc Qty Loc Code

FP17 18  
58573 11  
58906 7

D3793-1 Manufactured No 230 Each 12.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP18 12  
59151 12

X8 10/07/20

X4 10/07/20

X1 10/07/20

X1 10/07/20

June 28, 2010 11:32:49 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 28, 2010 11:32:49 AM

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Page 7

D3793-3



Wearshoe

Manufactured No

230 Each

11.0000

Start Date: 6/28/10

Start Qty: 1.00

Required Date: 7/05/10

Required Qty: 1.00

## Location

FP18

## Loc Qty

10

## Loc Code

FP19

10

1

1

57947

Manufactured No

230 Each

29.0000

D3794-1



Gasket

## Location

FP010

## Loc Qty

29

18

11

57942

59627

Manufactured No

230 Each

22.0000

D3794-3



Gasket

## Location

FP18

## Loc Qty

22

11

11

56066

59153

Purchased No

230 Each

766.0000

MS21043-6



NUT

## Location

ST301

## Loc Qty

766

766

112314

## Loc Code

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 28, 2010 11:32:50 AM

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Page 8

MS21083C8



NUT

Purchased

No

230

Each

93.0000

Start Date: 6/28/10

Start Qty: 1.00

Required Date: 7/05/10

Required Qty: 1.00



Location

ST303

Loc Qty

93

Loc Code

7

86

230

Each

290.0000



NAS1611-005



O-RING

Purchased

No

113845

114934

Location

FP002

Loc Qty

290

190

100

230

Each

275.0000

Loc Code



NAS1611-010



O-RING

Purchased

No

106099

114220

Location

FP

Loc Qty

275

100

175

250

Each

79.0000

Loc Code



AN8C21A



BOLT

Purchased

No

110715

110915

Location

ST345

Loc Qty

79

39

40

113558

114653

Loc Code



113558

81 981 16/07/10

81 10/07/10

PTO=>

11/3558

Shop Packet Print

Page 8

June 28, 2010 11:32:50 AM

Dart Aerospace Ltd

W/O: 60159		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/20	230	Replace NAS1611-010 "O" Rings with D2594-3 / B59358	JS	10/07/20	X8		S 10/07/20

Part No: D350-636-014 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

June 28, 2010 11:32:57 AM

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Page 9

AN960C816L  
WASHER

Purchased No

250 Each

57.0000

Start Date: 6/28/10

Start Qty: 1.00

Required Date: 7/05/10

Required Qty: 1.00

## Location

ST348

110584

111424

## Loc Qty

57

54

3

## Loc Code

Manufactured No

250 Each

32.0000

## Location

ST466

55905

57949

## Loc Qty

32

12

20

## Loc Code

Manufactured No

250 Each

45.0000

## Location

ST065

57825

59127

## Loc Qty

45

3

42

## Loc Code

Purchased No

250 Each

864.0000

## Location

ST077

54363

## Loc Qty

864

864

## Loc Code

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Picklist Print

June 28, 2010 11:32:57 AM

Page 10

Work Order ID: 60159

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

93.0000



5   
NUT

*6/10/12*

Location

Loc Qty

Loc Code

ST303

93

113845

7

114934

86

*M114934*

June 28, 2010 11:32:57 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
		1		D2750-2	SKIDTUBE WELDMENT, RH
			1	D2750-3	SKIDTUBE WELDMENT, LH
1		1		D2750-4	SKIDTUBE WELDMENT, RH
	1			D3488-041	BLADE FITTING, LH
4	4	4	4	D3488-042	BLADE FITTING, RH
4	4			D3490-1	SPACER
		4	4	D3490-3	SPACER
8	8	8	8	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
		8	8	D3492-043	PLUG ASSEMBLY
1	1	1	1	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
3	3	3	3	D3536-25	GASKET
8	8	8	8	D3631-1	WEARPAD
1	1	1	1	D3791-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

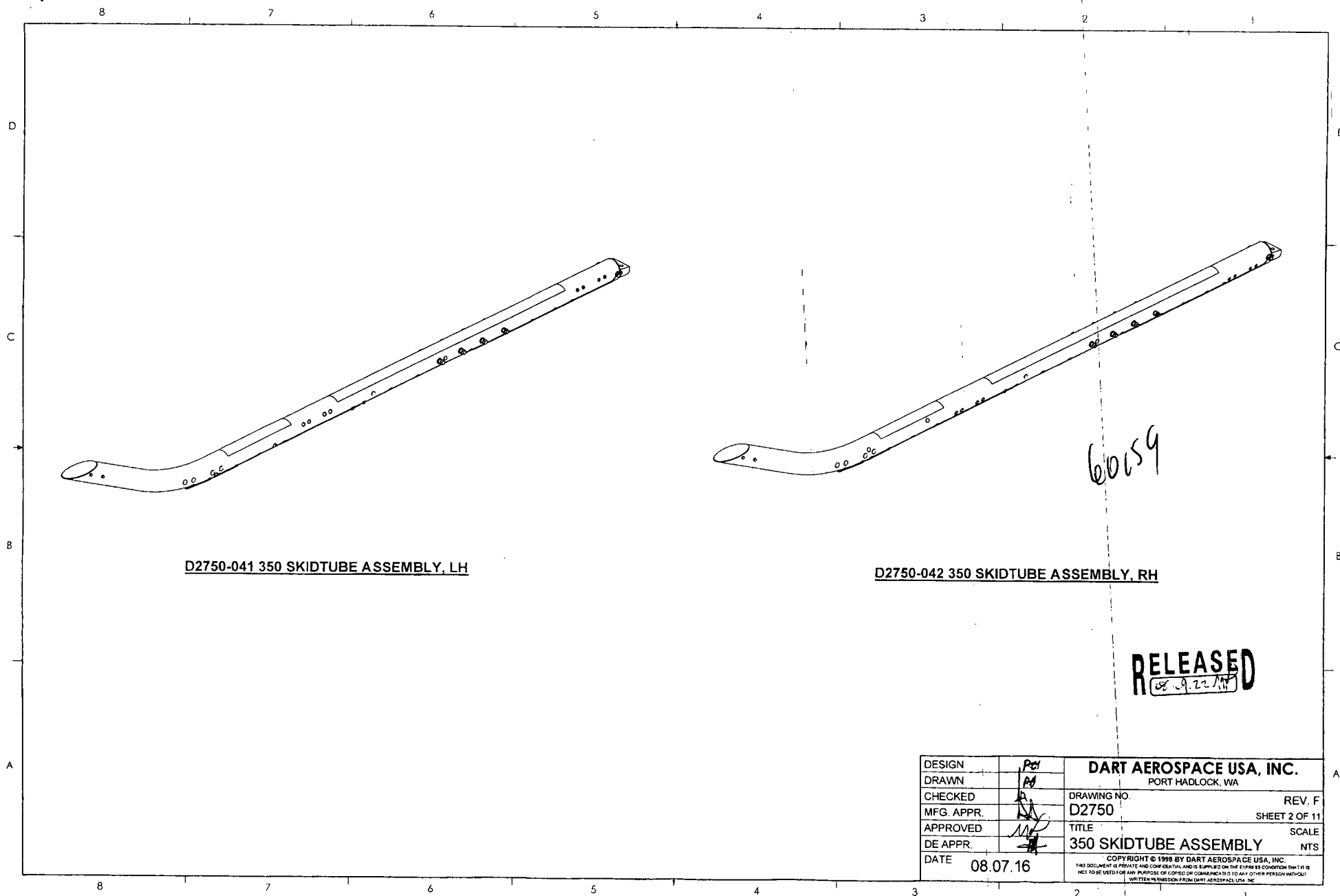
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH. ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF.  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

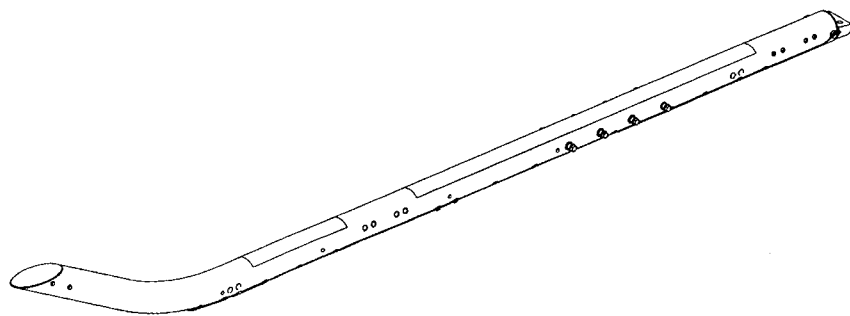
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	D2750
TITLE	350 SKIDTUBE ASSEMBLY
REV. F	SHEET 1 OF 11
SCALE	NTS

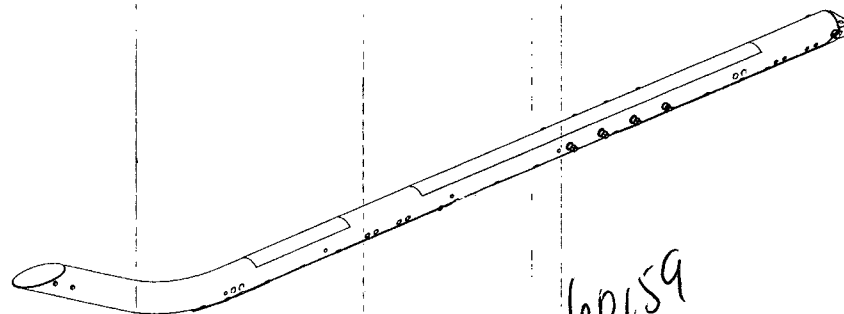
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RELEASED





D2750-043 350 SKIDTUBE ASSEMBLY, LH

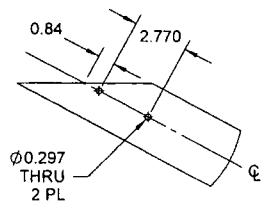
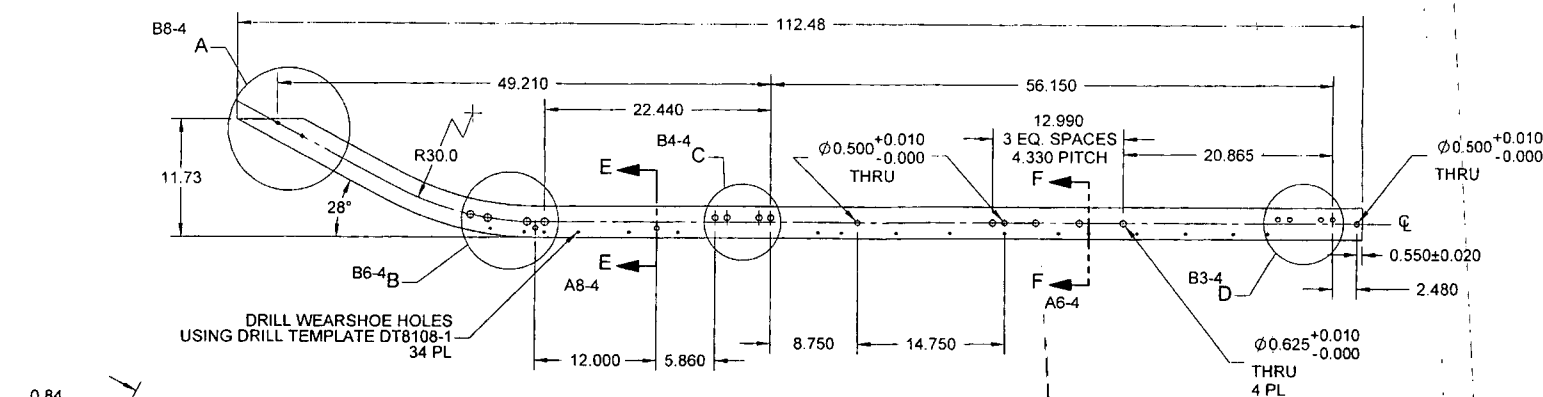


D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-22/100

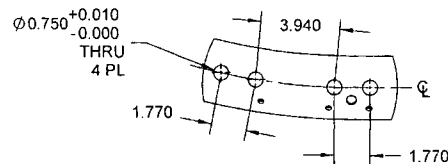
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DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
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# **D2750-1 LH SKIDTUBE**



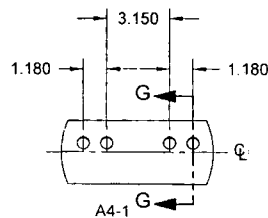
**DETAIL A**  
SCALE 2X

D7-4



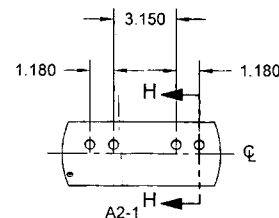
**DETAIL B**  
SCALE 2X

D7-4



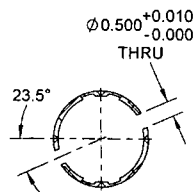
**DETAIL C**  
SCALE 2X

D5-4



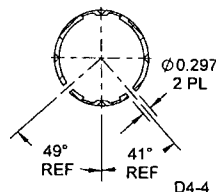
**DETAIL D**  
SCALE 2X

D3-4



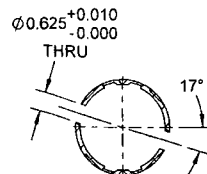
**SECTION E-E**  
SCALE 3X, 2 PL

D6-4



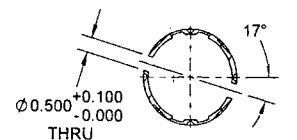
**SECTION F-F**  
SCALE 3X, 17 PL

D4-4



**SECTION G-G**  
SCALE 3X, 4 PL

B4-4



**SECTION H-H**  
SCALE 3X, 4 PL

B2-4

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

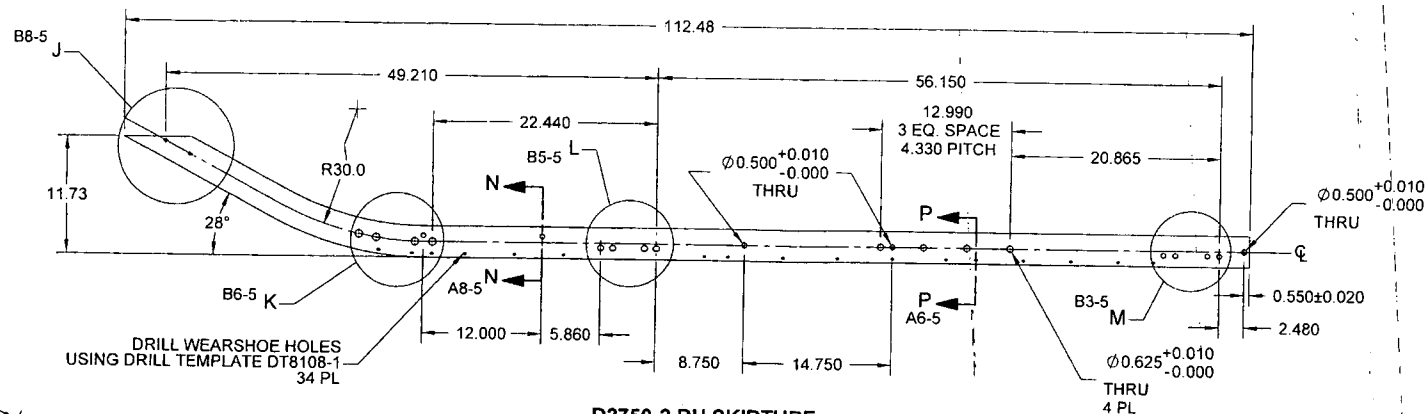
**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS  
SHEET 4 OF 11

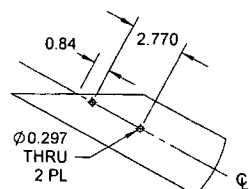
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60059

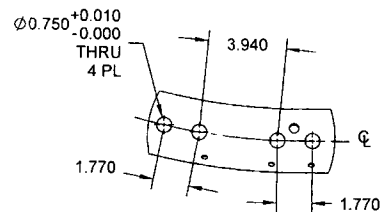
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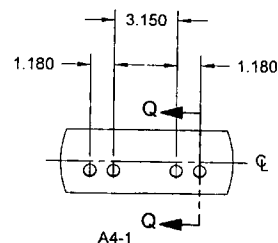
### D2750-2 RH SKIDTUBE



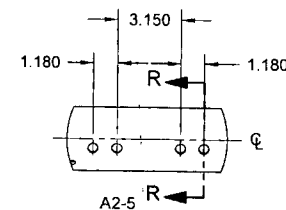
**DETAIL J**  
SCALE 2X



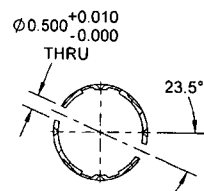
**DETAIL K**  
SCALE 2X



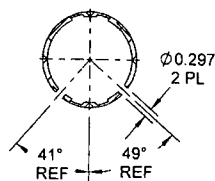
**DETAIL L**  
SCALE 2X



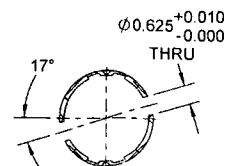
**DETAIL M**  
SCALE 2X



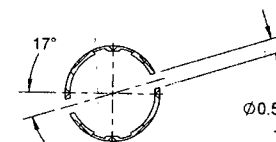
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8

7

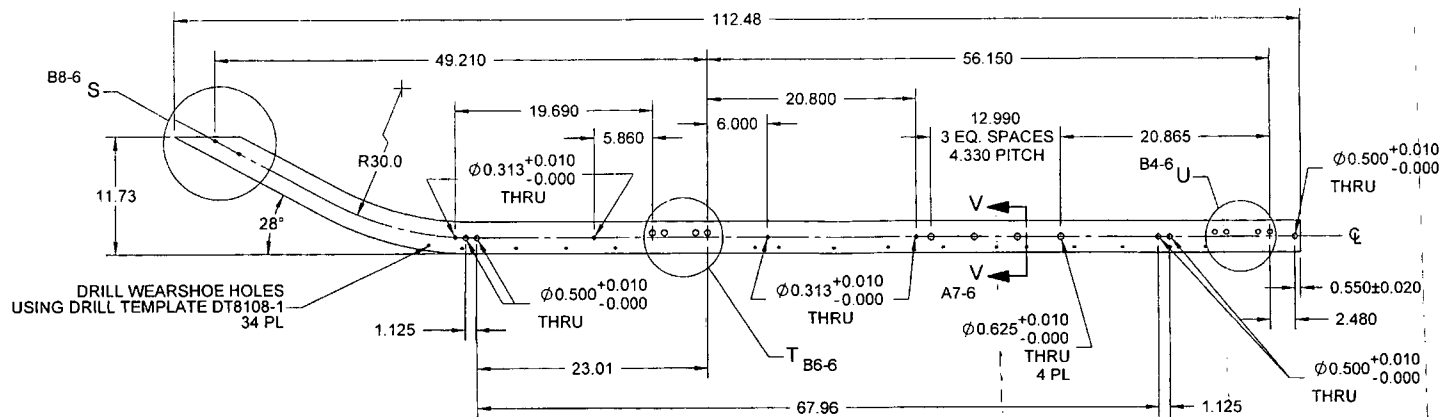
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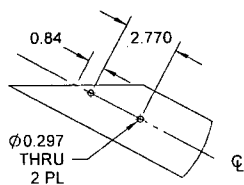
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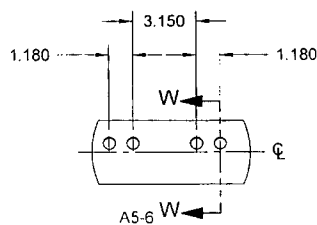
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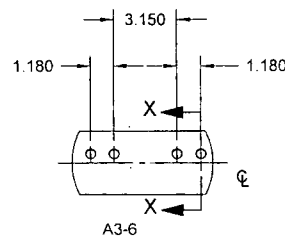
**D2750-3 LH SKIDTUBE**



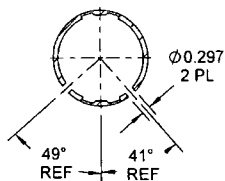
**DETAIL S**  
SCALE 2X



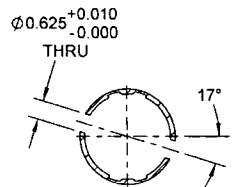
**DETAIL T**  
SCALE 2X



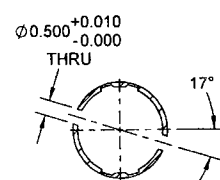
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL







**SECTION W-W**  
SCALE 3X, 4 PL



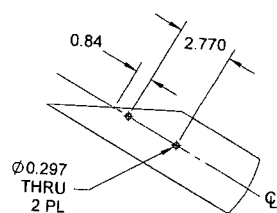
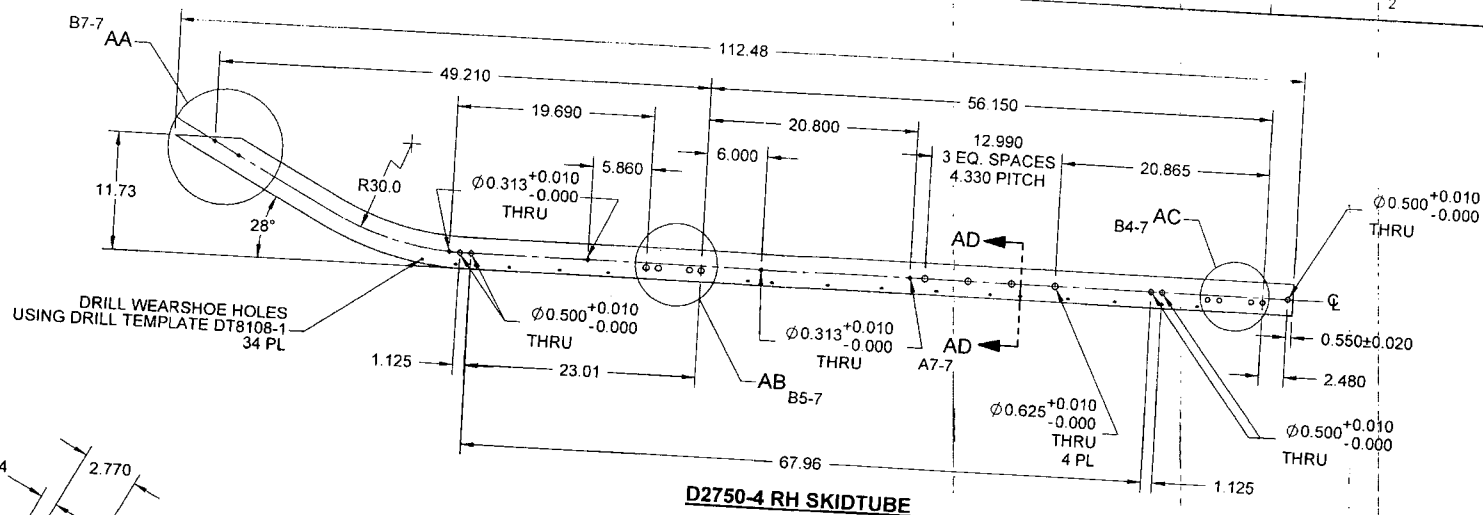
**SECTION X-X**  
SCALE 3X, 4 PL

60059

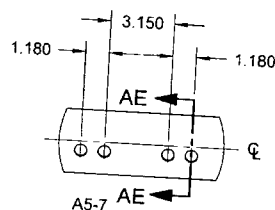
**RELEASED**  
08-07-16

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC.	
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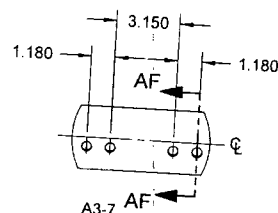




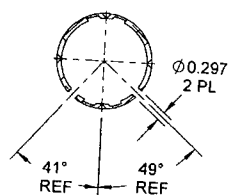
D7-7



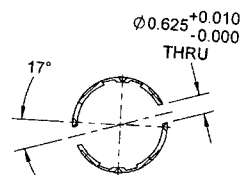
C4-7



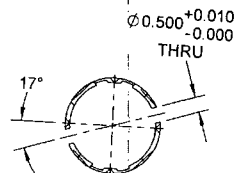
D3-7



D3-7



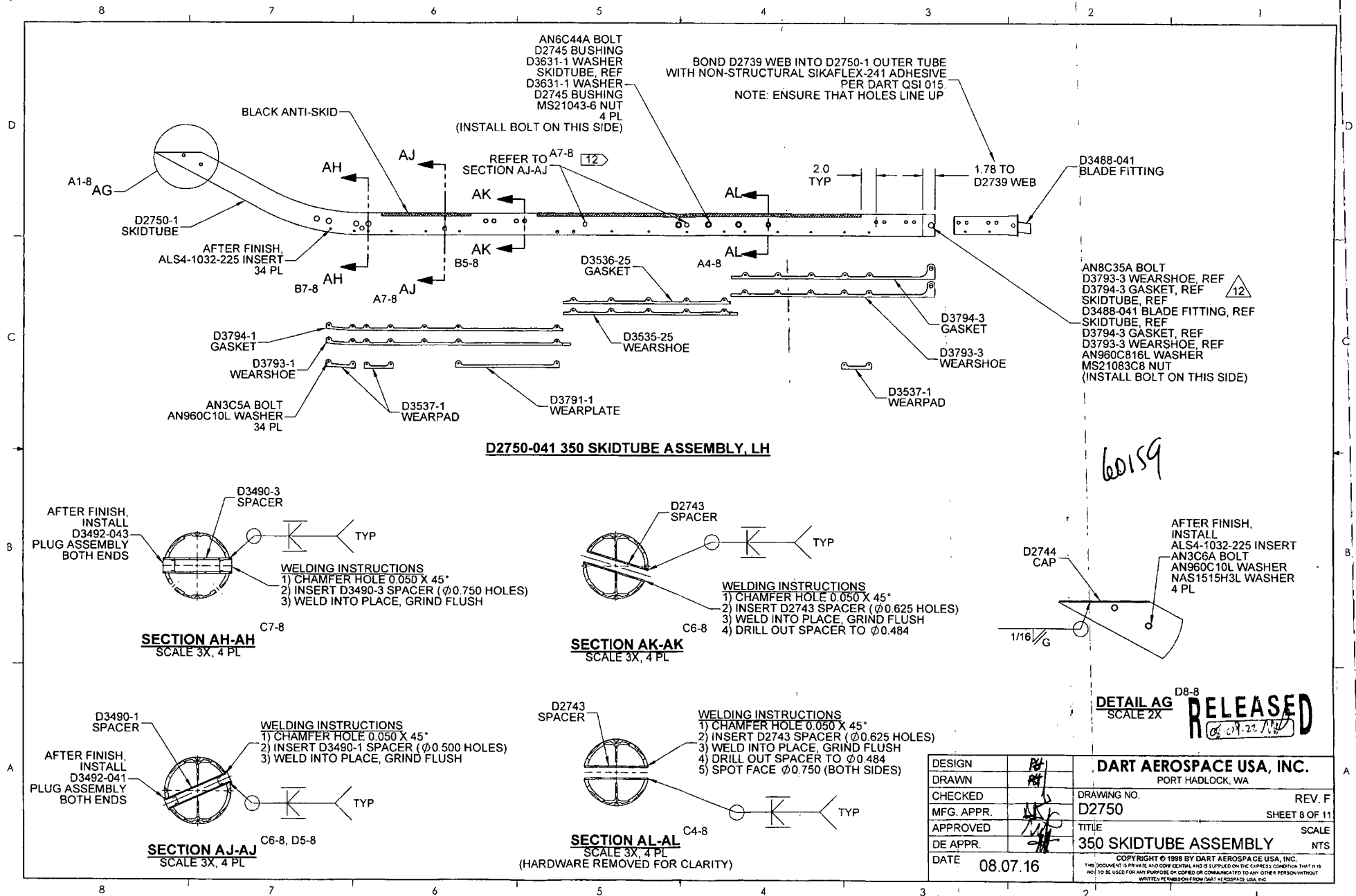
B6-7



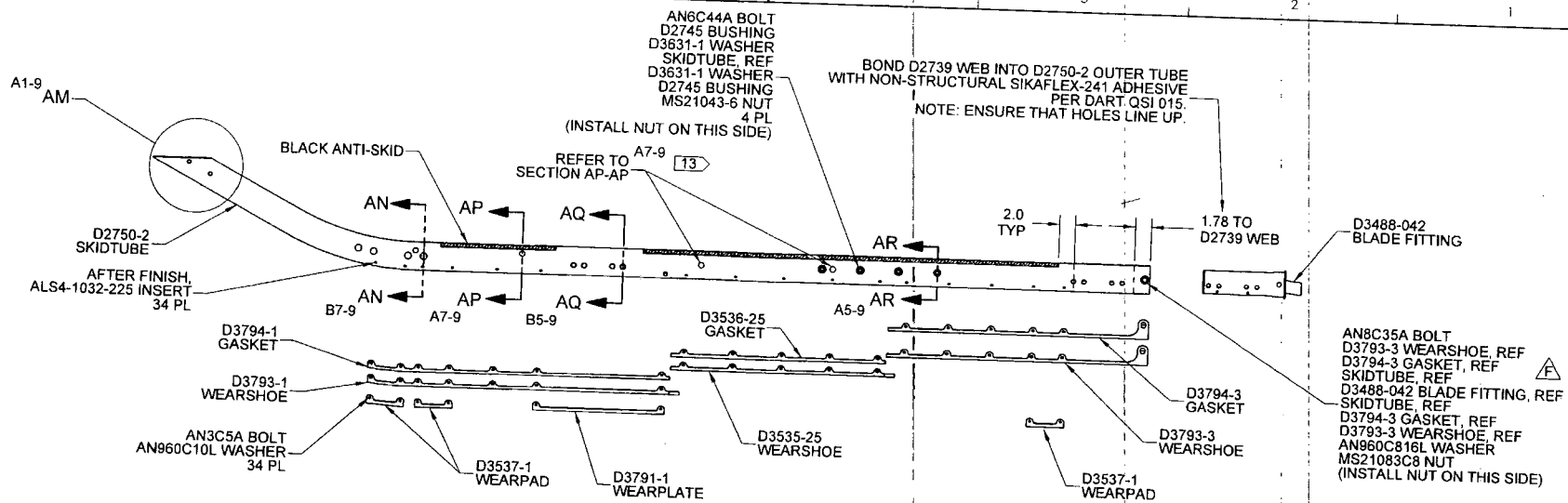
B4-7

**RELEASED**

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

**SECTION AN-AN**  
SCALE 3X, 4 PL

**SECTION AQ-AQ**  
SCALE 3X, 4 PL

**SECTION AP-AP**  
SCALE 3X, 4 PL

**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**DETAIL AM**  
SCALE 2X

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 9 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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A1-10  
AS

BLACK ANTI-SKID

REFER TO  
SECTION AW-AW

A4-10

(INSTALL BOLT ON THIS SIDE)

AN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL

AT

AU

AV

AW

2.0  
TYP1.78 TO  
D2739 WEBBOND D2739 WEB INTO D2750-3 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015  
NOTE: ENSURE THAT HOLES LINE UP.D3488-041  
BLADE FITTINGD2750-3  
SKIDTUBEAFTER FINISH,  
ALS4-1032-225 INSERT  
34 PLREFER TO  
SECTION AU-AU

A7-10

B7-10

D3536-25  
GASKET

A7-10

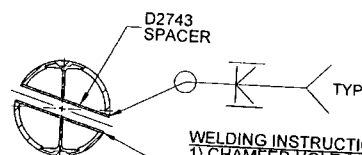
B4-10

AU

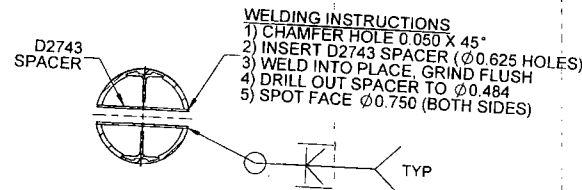
AV

AW

A4-10

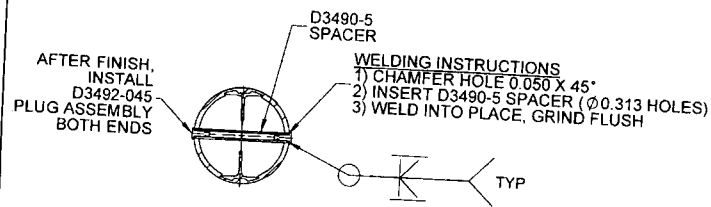
D3794-1  
GASKETD3793-1  
WEARSHOEAN3C5A BOLT  
AN960C10L WASHER  
34 PLD3537-1  
WEARPADD3791-1  
WEARPLATED3535-25  
WEARSHOED3794-3  
GASKETD3793-3  
WEARSHOED3537-1  
WEARPADAN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-041 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL BOLT ON THIS SIDE)**D2750-043 350 SKIDTUBE ASSEMBLY, LH**WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484**SECTION AT-AT**  
SCALE 3X, 4 PL

D6-10

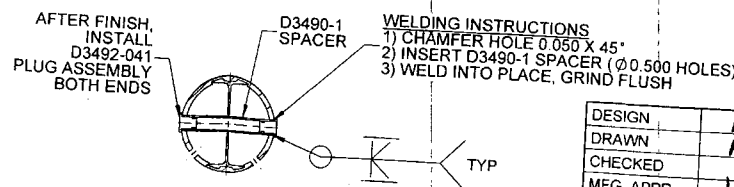
WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484  
5) SPOT FACE Ø0.750 (BOTH SIDES)**SECTION AV-AV**  
SCALE 3X, 4 PL

D4-10

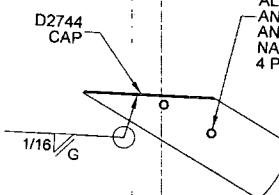
(HARDWARE REMOVED FOR CLARITY)

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH**SECTION AU-AU**  
SCALE 3X, 4 PL

D5-10, D6-10

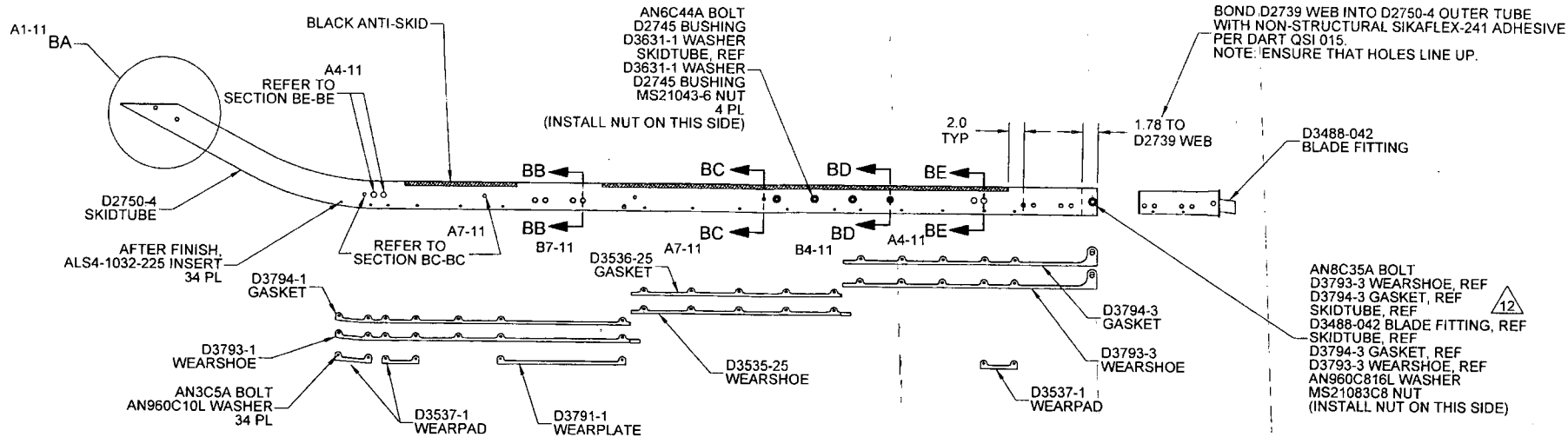
WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH**SECTION AW-AW**  
SCALE 3X, 4 PL

D4-10, D7-10

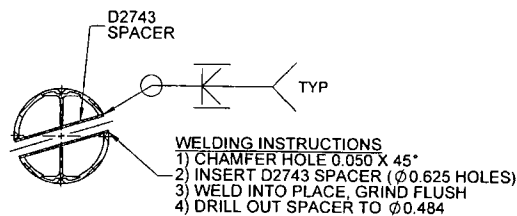
**DETAIL AS**  
SCALE 2XAFTER FINISH,  
INSTALL  
ALS4-1032-225 INSERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL**RELEASED**  
08.07.16

DESIGN	RE	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	DRAWING NO.	REV. F
DRAWN	RE		D2750	SHEET 10 OF 11
CHECKED	RE		TITLE	SCALE
MFG. APPR.	RE		350 SKIDTUBE ASSEMBLY	NTS
APPROVED	RE		DATE	08.07.16
DE APPR.	RE	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

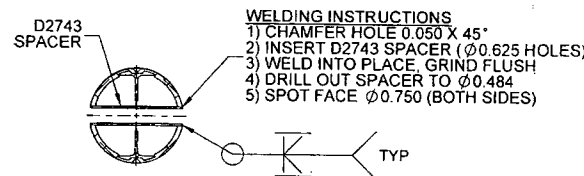
8 7 6 5 4 3 2 1



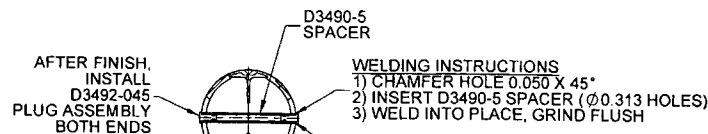
# **D2750-044 350 SKIDTUBE ASSEMBLY, RH**



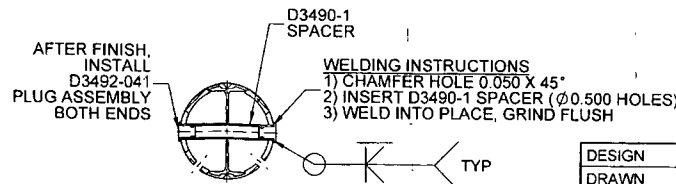
**SECTION BB-BB**  
SCALE 3X, 4 PL



**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL

**RELEASED**  
60159



**DETAIL BA**  
SCALE 2X

DESIGN	18	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	18	
CHECKED	18	
MFG. APPR.	18	
APPROVED	18	
DE APPR.	18	DRAWING NO. D2750
DATE	08.07.16	REV. F SHEET 11 OF 11
		TITLE 350 SKIDTUBE ASSEMBLY
		SCALE NTS

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NO. 234

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Berclay Elliott  
Job number: 59818  
Part number: D350-626-01  
Description: 300 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. D. A. Date of Test Coupon 10-06-21

Welder Berclay Elliott Date of Test Coupon 10-06-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld